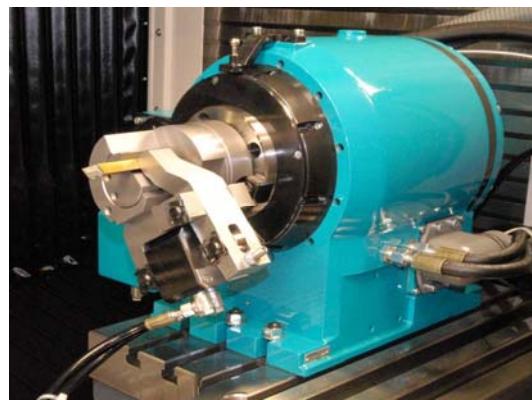


Gear Blade Oerlikon

A12-500

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face.



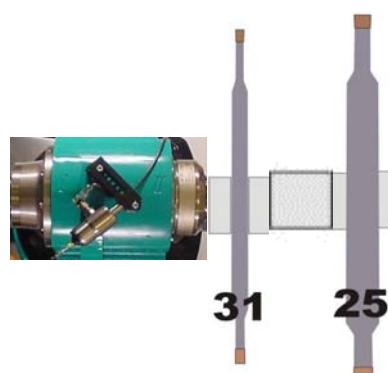
1. Cycletime for Resharpening

Tool specifications inner blade and outer blade 469; 14 x 17 x 115 mm Material HSS						
Operations	Probe	Prs.Side rough	Clr.Side rough	Prs.Side fin.	Clr.Side fin.	Chipbreaker
Feed [mm/Min]	2000	40	40	80	80	70
Power [kW]		1	1	1	1	1
Cutting feed [m/s]		32	32	32	32	32
Used wheels		25	25	31	31	31
Grinding time [s]	18	109	109	27	27	32
Total cycle time	5 Min 22					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

25 Ø250 1A1 B126
31 Ø250 14A1 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP, 23.4.09

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